

Work Order ID 114237

May-23-14 10:10:59 AM

\*114237\*

Page 1

Item ID: D4930-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Bearpaw

Start Date: 3/04/14

Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 3/04/14

Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals:

Process Plan: W

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4930

B

105

0.00

\*105\*

Purchasing

Memo

0.00

Purchasing

ISSUE PO

24350

CUT BLANK AS PER FILE D4930-1 BLANK

CL 14/05/268

112

Receive & Inspect for Damage & Mat'l Certs

0.00

\*112\*

Packaging

Memo

0.00

Packaging

8X 88 14-670

115

QC6- Inspect dimensions to drawing

0.00

\*115\*

QC

Memo

0.00

Quality Control

OK 14/06/13

8 6

**Work Order ID 114237**

May-23-14 10:10:59 AM

**\*114237\***

Page 2

Item ID: D4930-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

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Item Name: Bearpaw

Start Date: 3/04/14

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**\*8\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

0.00

**\*120\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FB217 and Dwg

FOLIO REV: AADWG REV: B

3-Deburr

81 14-06-13 19/06/14  
8 0

130

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*130\***

QC

Memo

0.00

Quality Control

81 14-06-13 19/06/14  
8 0

**Work Order ID 114237**

May-23-14 10:10:59 AM

**\*114237\***

Page 3

Item ID: D4930-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw

Start Date: 3/04/14

Start Qty: 8.00

**\*g\***

Cust Item ID:

Required Date: 3/04/14

Req'd Qty: 8.00

**\*g\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC8- Inspect parts - second check

0.00

D.A. 14/06/14

8

0

DAS  
08  
9-89**\*140\***

QC

Memo

0.00

Quality Control

150

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*150\***

Packaging

Memo

PPP 114376

0.00

14/6/16

8

DAS  
32  
9-89

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

14/6/17

ME

14-6-16

# Picklist Print

May-23-14 10:10:59 AM

Page 1

Work Order ID: 114237

\*114237\*

Parent Item: D4930-1

\*D4930-1\*

Parent Item Name: Bearpaw

Start Date: 3/04/14

Required Date: 3/04/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 13-10-07 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

sf

400.0000

11

\*MUHMWB10\*

\*\*

02/14/05/28

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

Location

Loc Qty

Loc Code

MAT018

400

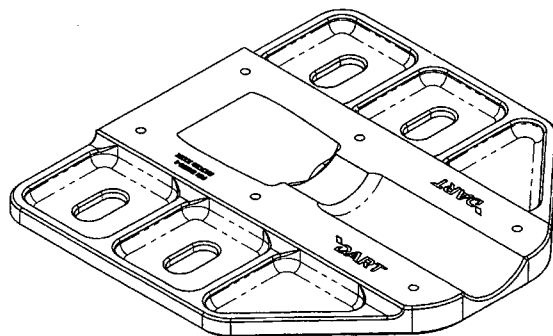
m128267

47

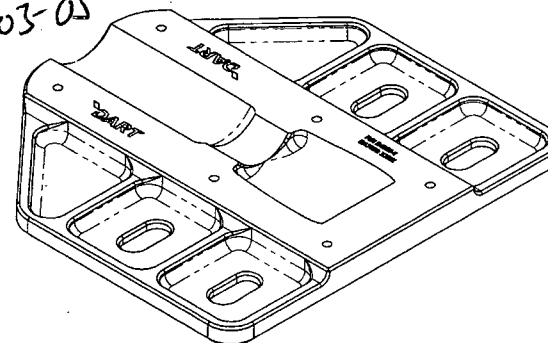
m128668

353

m129293



114 237 MCJ  
14-03-05



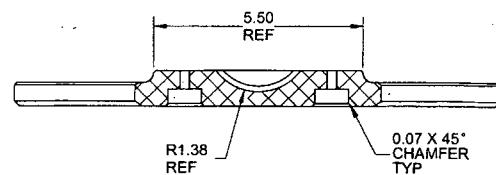
RELEASED  
2013-12-12

# D4930-1 BEARPAW

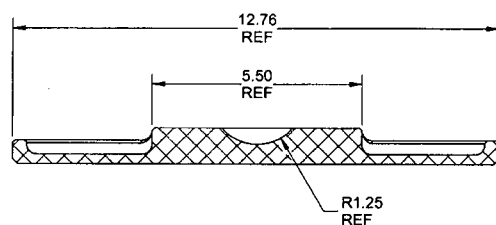
B	MOVE CLAMP HOLES 0.250" APART, ZN B2-3, B2-5, ADJUST TANGENT POINT, ZN C7-3, ADJUST RADIUS, ZN C5-3, B5-3, MOVE CLAMP HOLES AFT, ZN B1-3	VS	13.12.05
A	NEW ISSUE	VS	13.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4930	SHEET 1 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BEARPAW	NTS
DATE	13.12.10	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ANY REPRODUCTION OR DISSEMINATION OF THIS DOCUMENT IS PROHIBITED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

APPROVED

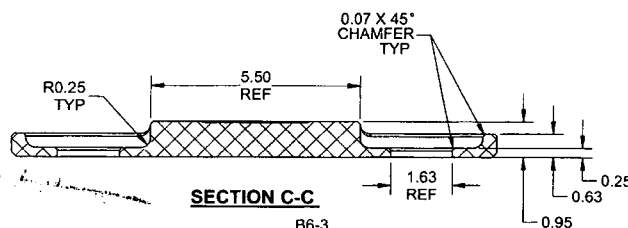




**SECTION A-A**  
B6-3

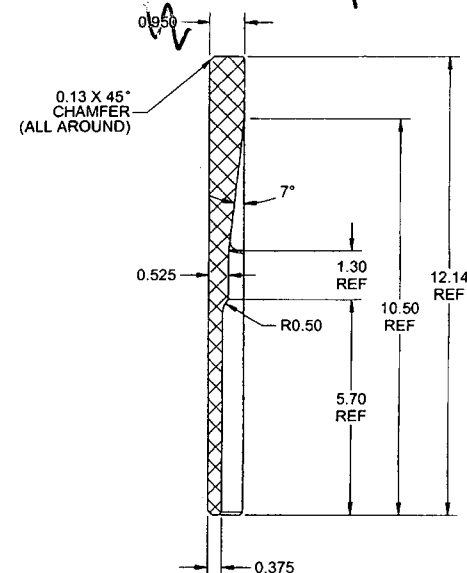


**SECTION B-B**  
C6-3



**SECTION C-C**  
B6-3

**D4930-1 BEARPAW**



**SECTION D-D**  
C6-3

RELEASED  
2013-12-12

APPROVED	DESIGN	VS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	HS	DRAWING NO.	REV. B
	MFG. APPR.	JLM	D4930	SHEET 4 OF 6
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	BEARPAW	NTS
DATE		13.12.10	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO24350**

Purchase Order Date 5/26/2014

PO Print Date 5/26/2014

Page Number 4 of 4

**Order From :**

VC-TPI001

**Ship To :** DART AEROSPACE LTD

TPI INDUSTRIES INC.  
148 RUE GOODFELLOW  
DELSON, QUEBEC J5B 1V4  
CANADA

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**Contact Name**

**Vendor Phone** 450-633-0484

**Ship To Contact**

**Ship To Phone**

**Ship Via:** Day & Ross collect

**Ship Acct:**

**Buyer**

Chantal Lavoie

**Customer POID**

**Customer Tax #**

10127-2607

**Terms**

Net 30

**Currency**

CAD

**FOB**

Destination-Collect

10	114239	D4796-1 BEARPAW	6/13/2014 Yes 6/13/2014	8.00 ✓	\$44.64	\$357.1
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CUT BLANK AS PER FILE

**Line Total:** ~~\$357.1~~

11	114237	D4930-1 BEARPAW	6/13/2014 Yes 6/13/2014	8.00 ✓	\$22.54	\$180.3
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CUT BLANK AS PER FILE

**Line Total:** ~~\$180.3~~

12	118920	D4930-3 BEARPAW	6/13/2014 Yes 6/13/2014	10.00 ✓	\$25.29	\$252.8
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CUT BLANK AS PER FILE

**Line Total:** ~~\$252.8~~

**PO Total:** ~~\$3,252.3~~

8014-6-10

W C L

**Note:** Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

Change Nbr:

1

Change Date: 5/26/2014



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b>		<b>Part Number:</b>	
<b>Inspection Dwg:</b>	<b>Rev:</b>	<b>Page 2 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.45	<del>±</del> $\pm 0.030$	0.479	✓			
4.250	$\pm 0.010$	4.250	✓			
5.870	"	5.870	✓			
1.143	"	1.143	✓			
3.850	"	3.850	✓			
5.50	$\pm 0.030$	5.505	✓			
0.07	"	0.058	✓			
12.76	"	12.760	✓			
5.50	"	5.505	✓			
0.07	"	0.068	✓			
0.25	"	0.266	✓			
0.63	"	0.643	✓			
0.95	"	0.973	✓			
1.63	"	1.623	✓			
<del>0.95</del>	<del><math>\pm 0.030</math></del>	<del>0.95</del>	<del>✓</del>			
12.14	$\pm 0.030$	12.140	✓			
10.50	"	10.500	✓			
1.30	"	1.300	✓			
5.70	"	5.700	✓			
0.375	$\pm 0.010$	0.376	✓			
0.525	"	0.535	✓			
0.13 x 45	$\pm 0.030$	0.133	✓			

<b>Measured by:</b>	<b>DAS</b> 02 BT	<b>Audited by:</b>	<b>DAS</b> 08	<b>Preliminary Approval:</b>	
<b>Date:</b>	14-06-13	<b>Date:</b>	14/06/14	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	114237
<b>Description:</b> Bean Pair		<b>Part Number:</b>	D4930-1
<b>Inspection Dwg:</b> D4930 <b>Rev:</b> B		<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.38	$\pm 0.030$	0.380	✓		Tap	BT -10
1.19	"	1.190	✓			
2.82	"	2.820	✓			
3.63	"	3.630	✓			
5.05	"	5.050	✓			
5.26	"	5.260	✓			
5.44	"	5.440	✓			
6.38	"	6.380	✓			
12.14	"	12.140	✓			
0.38	"	0.380	✓			
8.06	"	8.060	✓			
7.13	"	7.130	✓			
6.75	"	6.750	✓			
6.44	"	6.440	✓			
5.25	"	5.250	✓			
5.14	"	5.140	✓			
3.75	"	3.750	✓			
3.38	"	3.380	✓			
1.88	"	1.880	✓			
1.64	"	1.640	✓			
0.38	"	0.380	✓			
Ø 0.260	$+0.006/-0.001$	0.260	✓		vern	BT -4
0.88	$\pm 0.030$	0.883	✓			

<b>Measured by:</b> DAS 02 9-89 [Signature]	<b>Audited by:</b> J.A. DAS 08 9-89	<b>Preliminary Approval:</b>
<b>Date:</b> 14-06-13	<b>Date:</b> 14/06/14	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

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